

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020411**Date Inspected:** 05-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

OBG Segment 9CW-9DW

Shielded Metal Arc Welding (SMAW) in the 4G position of Bottom Panel splice weld VT repair area. Weld # OBW9C-003. The welder is identified as 062935. ZPMC Quality Control (QC) is identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair-1. See attached photograph Pic\_001.

OBG Segment 9CW-9DW

Shielded Metal Arc Welding (SMAW) in the 4G position of Counterweight side EP to SP holdback weld. Weld # 9DW-CA065-001 & 9CW-CA061-005. The welders are identified as 066038 & 067765. ZPMC Quality Control (QC) is identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-U4b-FCM. See attached photograph Pic\_002.

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### OBG Segment 9BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Counterweight connection plate. Weld # OBW9K-004. The welders are identified as 066413 & 067571. ZPMC Quality Control (QC) is identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-U4b-FCM.

### OBG Segment 9CW-9DW

Shielded Metal Arc Welding (SMAW) in the 4G position of Cross beam side EP to SP holdback weld. Weld # 9CW-CA062-001 & 9DW-SEG055A-039. The welders are identified as 067609 & 067764. ZPMC Quality Control (QC) is identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-U4b-FCM.

### OBG Segment 9CW-9DW

Shielded Metal Arc Welding (SMAW) in the 3G position of Cross beam side DP 'I' rib splice weld. Weld # DP686-001-19. The welder is identified as 044551. ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3B.

### OBG Segment 9CW-9DW

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as 9AW-9BW Cross beam side 'I' rib hold back weld as per ZPMC notification # 06341.

The weld designations reviewed are as follows:

DP683-001-017 and 018

DP684-001-007 and 008

EP124-001-009 and 010

EP125-001-013 and 014

SP668-001-021, 022, 029 and 030

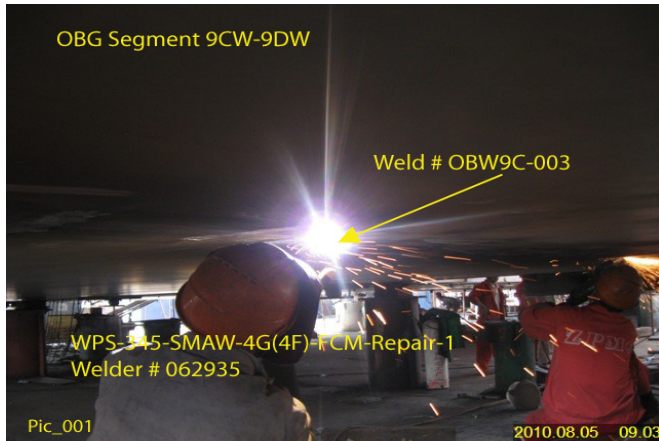
SP669-001-021, 022, 029 and 030

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### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gade,Ramesh	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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